

Work Order ID 56098

February 10, 2010 12:16:02 PM

Page 1

Item ID: D3443-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 2/10/10 Start Qty: 6.00

Required Date: 2/26/10 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: WDate: 10-2-10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3443

Rev C

0.00

100

0.00



BAND SAW

Bandsaw

Memo

0.00

G.A 10/02/13

6 0

Jeaspa Bandsaw

Cut blank 2.400 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

G.A 10/02/14

6 0

HAAS CNC vertical machine #1

Machine as per Folio FA587 Rev: C & Dwg D3443 Rev: C

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

G.A 10/02/14

6 0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56098

February 10, 2010 12:16:02 PM

Page 2

Item ID: D3443-1

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Setup Start

Revision ID:

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Item Name: Lug

Start Date: 2/10/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: CARL

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Rec'd 2/18 (5) P107

10/02/18

MF

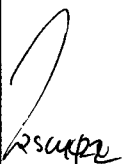

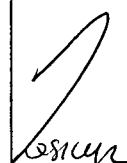
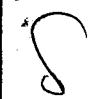
10-2-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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10/02/17	# 110	Found @ Packegins /Store that the two threaded holes were tapped poorly. Qty x1 part affected R.C. Chip build-up / process Lack of attention: Ended up in stores.		Scrap + Destroy cannot replace Qty x1	S.M.D. 10-02-17	 10/02/17		 10/02/17

NOTE: Date & initial all entries

Picklist Print

February 10, 2010 12:16:06 PM

Page 1

Work Order ID: 56098



Parent Item: D3443-1

Parent Item Name: Lug

Start Date: 2/10/10

Required Date: 2/26/10

Comments: A05.11.14 New issue EC
IPP Rev:B Removed Tumbling 08-09-08 JLM Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B2.500X1.250		Purchased	No			100	f	9.8136	1.2632			
17-4 SS BAR 2.500 x 1.250												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

110378

9.8136

9.8136

1.2000 ft M.A 10/02/13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	56098
Description: Lug		Part Number:	D3443-1
Inspection Dwg: D3443	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	.991	/	/		
0.342	+0.000/-0.005	.337	/	/		
0.329	+/-0.010	.329	/	/		
Ø0.500	+0.000/-0.005	.498	/	/		
2.21	+/-0.030	2.213	/	/		
Ø0.656	+0.000/-0.001	.656	/	/		
0.625	+/-0.010	.625	/	/		
0.95	+/-0.030	.95	/	/		
2.230	+/-0.010	2.225	/	/		
0.229	+/-0.010	.229	/	/		
0.370	+/-0.010	.370	/	/		
0.525	+/-0.010	.525	/	/		
0.524	+/-0.010	.524	/	/		
0.390	+/-0.010	.390	/	/		
1.048	+/-0.010	1.043	/	/		
0.05 x 45°	+/-0.5°	.05 x 45°	/	/		
R0.032	+/-0.010	R.032	/	/		
0.470	+/-0.010	.470	/	/		
0.165	+/-0.010	.162	/	/		
1/4-28UNF	N/A	1/4-28	/	/		

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10-21-10/2/14	Date:	10/02/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	
B	09.11.04	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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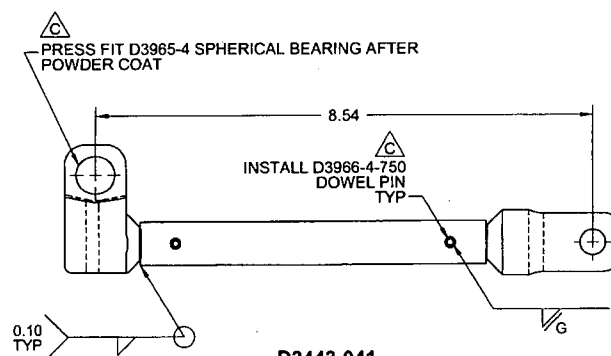
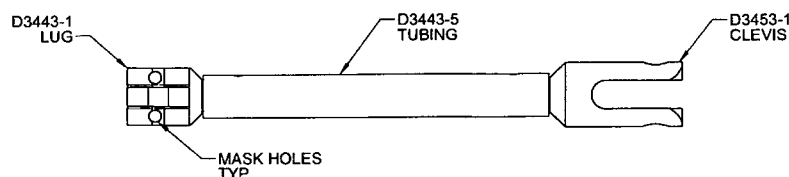
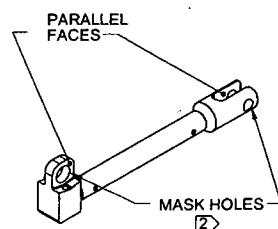
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54098
BJ10-2-10

RELEASED
9/18/25 M

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPANNAUR P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D3443	REV. C SHEET 1 OF 4
CHECKED		TITLE STRUT WELDMENT ASSEMBLY NTS	SCALE
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APPROVED		DATE	09.06.25
DE APPR.			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

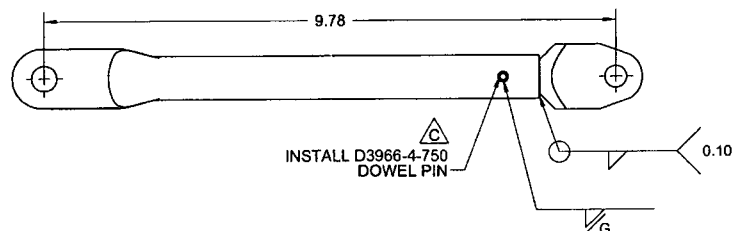
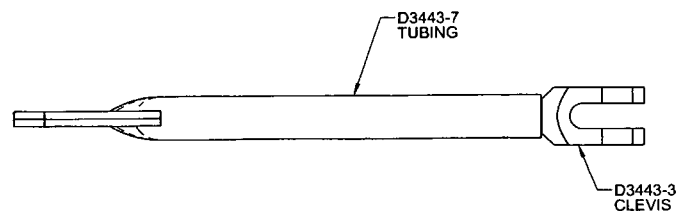
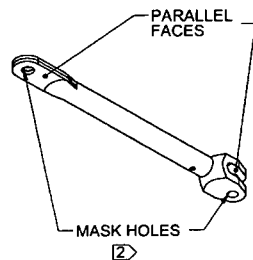
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3

2

1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

RELEASED
09/06/25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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W/0 56098

W/O:		WORK ORDER CHANGES					
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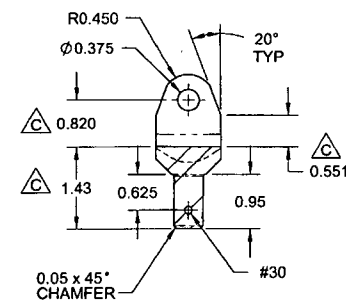
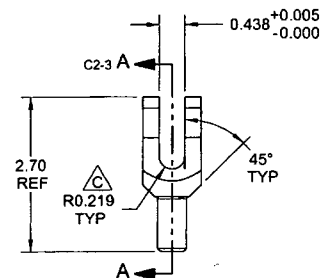
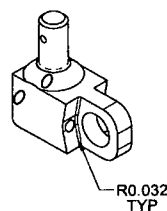
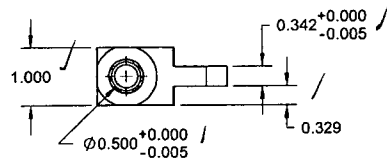
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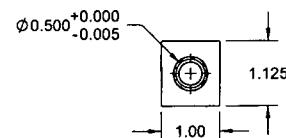
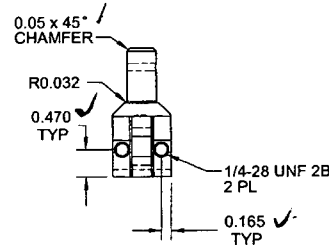
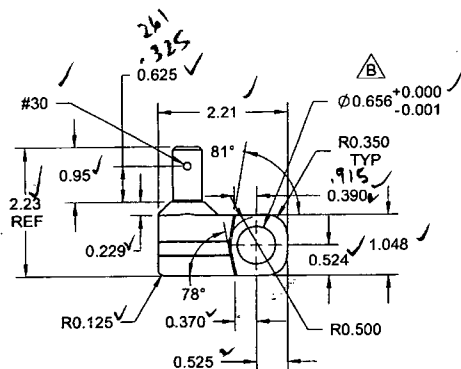
NOTE: Date & initial all entries

328

8 7 6 5 4 3 2 1



SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

RELEASED
09/06/25/11/13

W/O 56098

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
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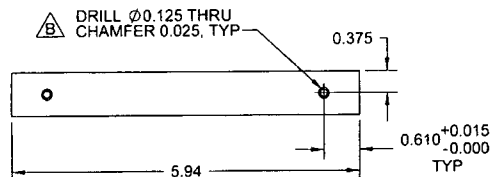
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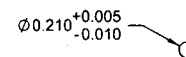
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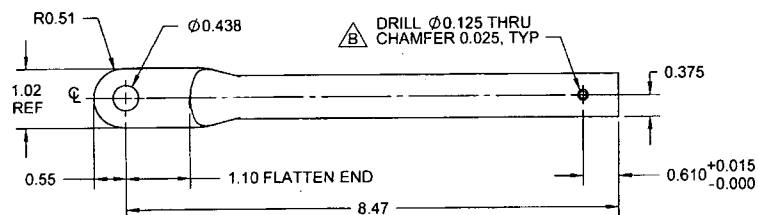
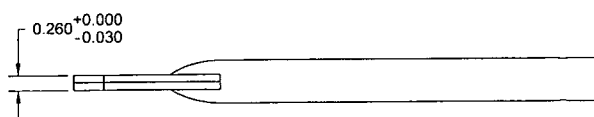
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

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07/25/14

W10 56098

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG APPR.	RF	D3443	SHEET 4 OF 4
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